



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5720-5
Job Sheet 194696



Part No: D5720-5

Job Qty: 10 pcs

Part Name: Radius Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 5/8/19

Description:

Note: DWG D5720 REV.A IPP REV:A 19.04.03 NEW ISSUE DD VERF:JFS IPP REV:B 19.04.23 AS PER REV.A
DWG DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Omax - 1	10 pcs	5/8/19	5/8/19	0.00	1.00	Waterjet - Omax		DL19/05/07
120	QC 2	10 pcs	5/8/19	5/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DL19/05/07
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

				QC 2 - 65		
				QC 2 - 71		
130	Conventional Mill - 1 - B4B	10 pcs	5/8/19	0.00 0.50	Conventional Mill - 1 - B4B	/
					Conventional Mill - 2 - B4B	
140	QC 2	10 pcs	5/8/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	11/19/15/8
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 71	
150	QC 8	10 pcs	5/8/19	0.00 0.00	QC 8 - 12	2/19/05/08
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
160	Packaging 3-1 - Stock - B4B	10 pcs	5/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	FL
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	10 pcs	5/8/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAC
				QC 21 - SA - 53	21 MAY 08 2019
Part Op 110 - 1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB 130 - Manufacture as per dwg MILL RADIUS AS PER DWG 140 - QC2- Inspect parts off machine FAI/FAIB 150 - QC8- Inspect parts - second check 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release					9-69
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304B0.250X4.000	304 Bar .250 X 4.00	.4000 ft (.04 ea)	110-Waterjet - Omax - 1	5061731	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Waterjet - Omax - 1	M304B0.250X4.000	0	13	0	
Part Specifications					
Specifications could not be found.					

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
Ø.129	±.001 +.005	Ø.128	1		Vs per -02	
Ø.316	±.001 +.006	Ø.317	1			
.325	+/- .010	.323	1			
.500	+/- .010	.499	1			
.70	+/- .030	.703	1			
.950	+/- .010	.949	1			
.250	+/- .010	.245	1			
.400	+/- .010	.397	1			
Manual Milling						
R0.19	± 0.030	0.188	1		Rad Cutter & Gage	

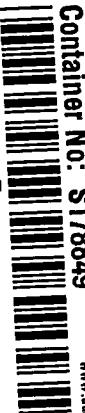
Measured by:	<i>DR</i> / 19/05/08	Audited by:	<i>DR</i>	Preliminary Approval:	
Date:	19/05/07	Date:	19/05/08	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	

DART

AEROSPACE

DART Aerospace Ltd.
1270 Aberdeen Street
Hewitsonburg, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S178849

Part: D5720-5

Job No: 194696

Serial No/Batch: S178849

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/07/19